

Work Order ID 58819

Wednesday, May 19, 2010 10:42:32 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 5/19/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 105-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B10-5-20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-5-20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/121

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP11

0.00

Packaging

Memo

0.00

Packaging

10-5-218/120

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/05/25MF
10-5-22

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 10:42:36 AM

Page 1

Work Order ID: 58819

Parent Item: D3536-23

Parent Item Name: Gasket

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	539.2531	1.3365	17.		



NEOPRENE SHEET 0.063

13 10-5-20

Location

Loc Qty

Loc Code

MAT

400

114691

400

MAT052

139.2531

114176

139.2531

114176

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58819
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	*			
48.20	+/-0.030	48.20	*			
44.70	+/-0.030	44.70	*			
39.31	+/-0.030	39.31	*			
33.92	+/-0.030	33.92	*			
28.53	+/-0.030	28.53	*			
23.14	+/-0.030	23.14	*			
17.75	+/-0.030	17.75	*			
14.25	+/-0.030	14.25	*			
9.50	+/-0.030	9.50	*			
4.75	+/-0.030	4.75	*			
8.00	+/-0.030	8.00	*			
16.00	+/-0.030	16.00	*			
24.00	+/-0.030	24.00	*			
32.00	+/-0.030	32.00	*			
39.00	+/-0.030	39.00	*			
48.00	+/-0.030	48.00	*			
0.30	+/-0.030	.304	A			
0.30	+/-0.030	.301	A			
1.89	+/-0.030	1.888	A			
Ø0.19	+0.005/-0.001	.191	A			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-20	Date:	10/5/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

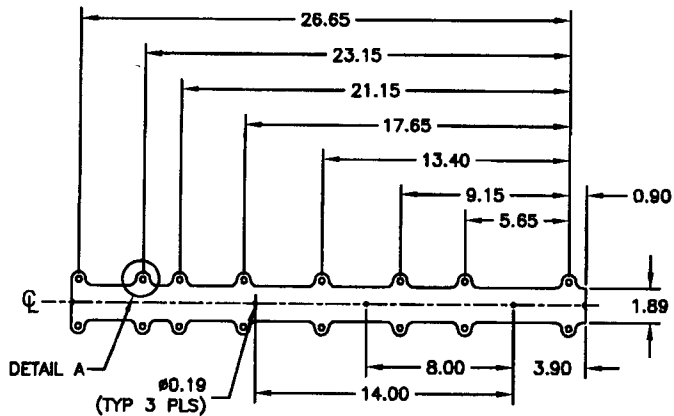
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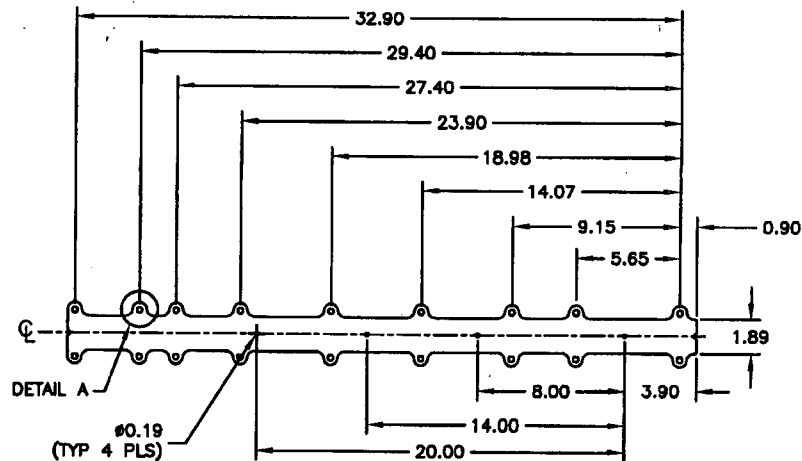
DART

RELEASED
08.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58119
2810-5-19



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	PH	D3536	SHEET 1 OF 6
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

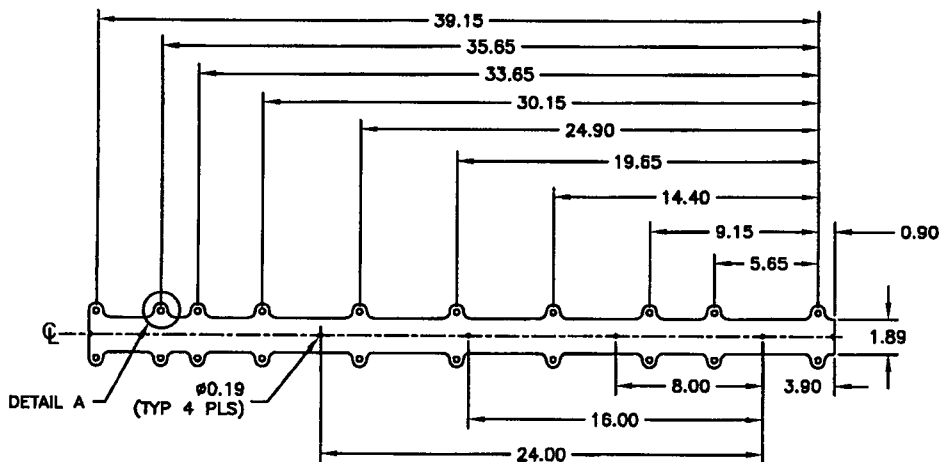
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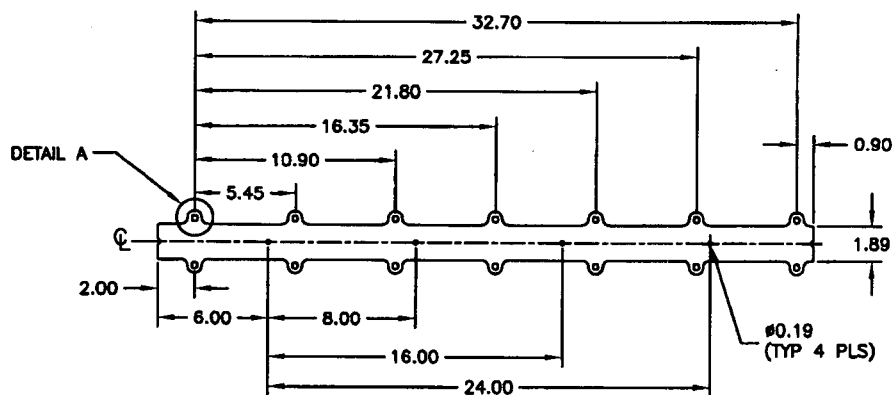
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

RELEASED
07.02.12

W/0 58819



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

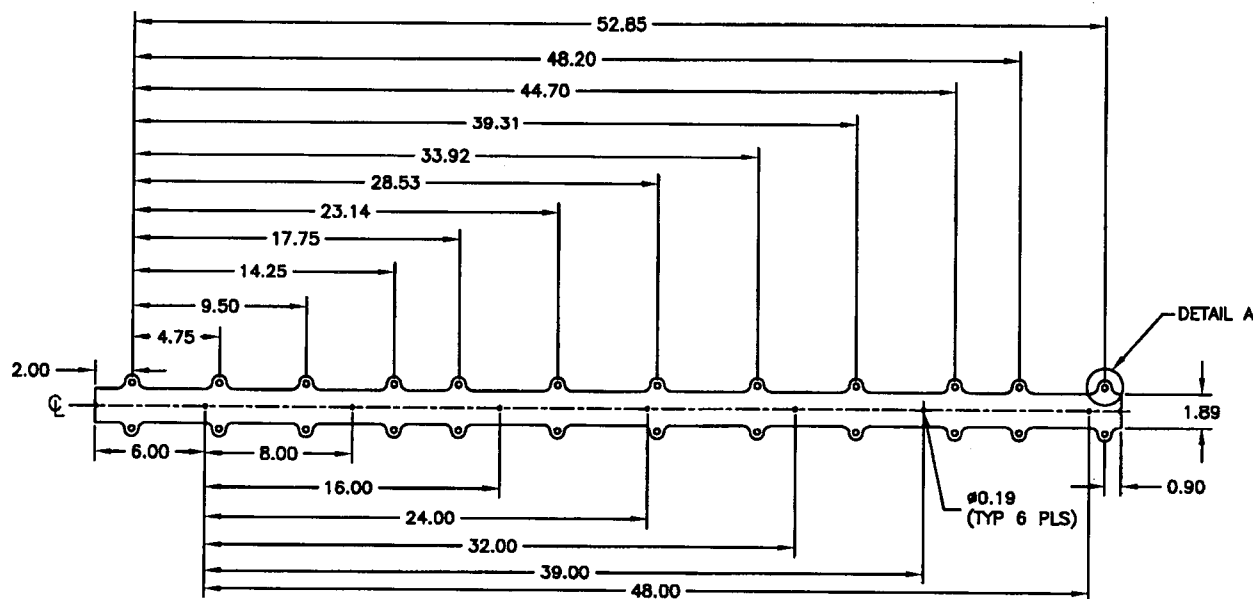
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NOTE: Date & initial all entries

DART

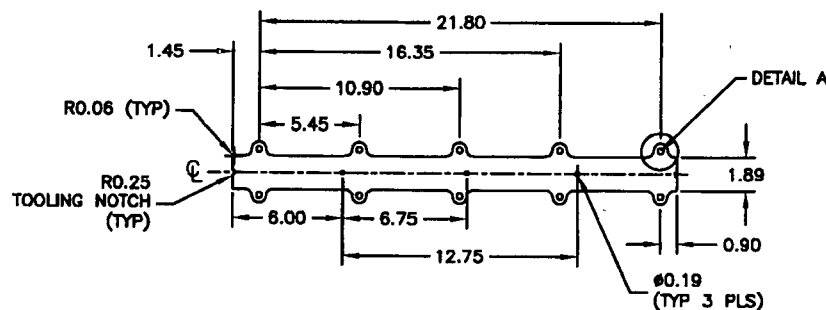
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

RELEASED
07.02.12



D3536-23 GASKET

w/o 58819



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

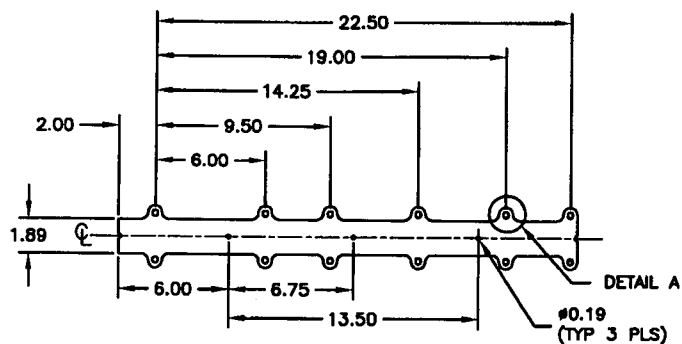
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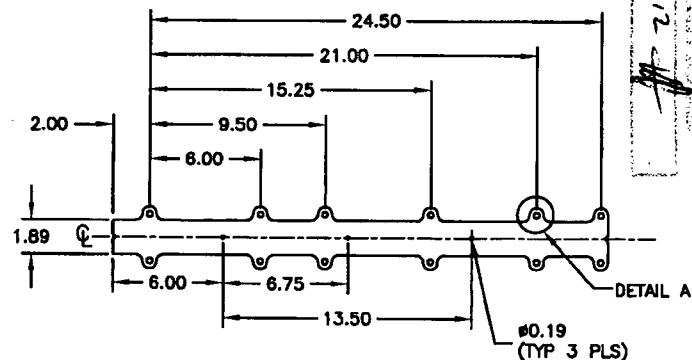
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC.
CHECKED PH	APPROVED PH	PORT HADLOCK, WA
DATE 06.10.25	TITLE GASKET	DRAWING NO. D3536
		SHEET 4 OF 6
		SCALE 1:10

RELEASED
07.02.12

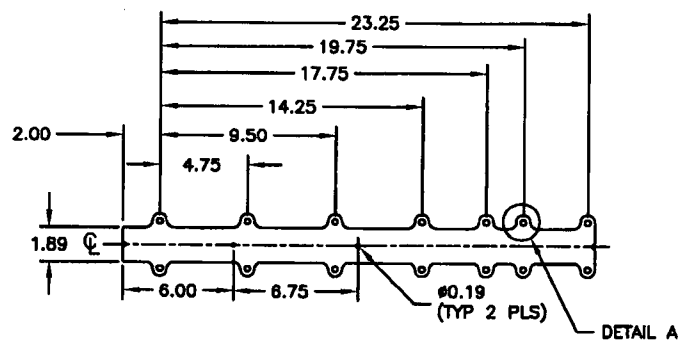


D3536-31 GASKET



D3536-33 GASKET

W/O 58819



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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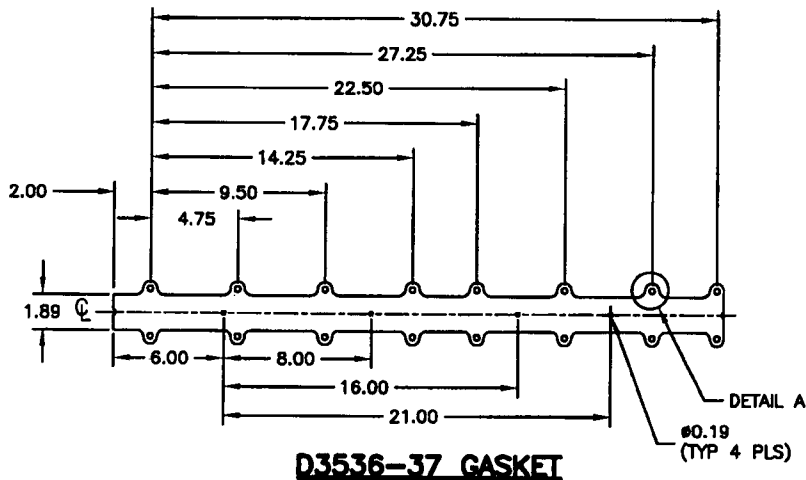
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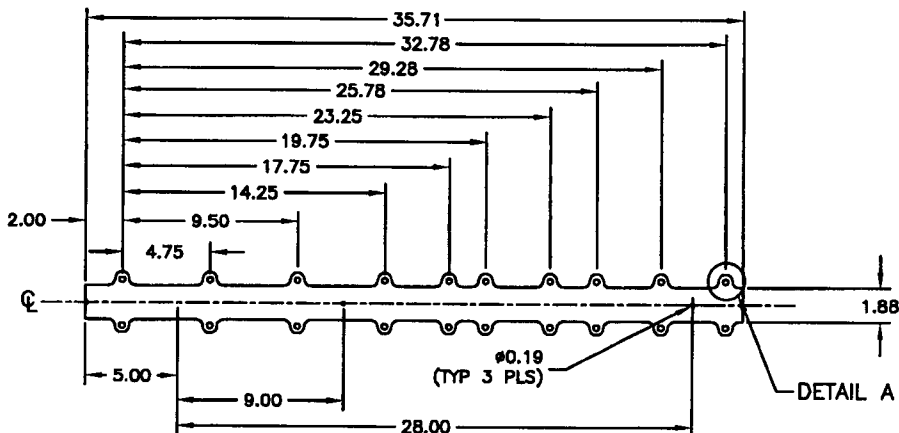
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

RELEASED
07.02.12

w/o 58819



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
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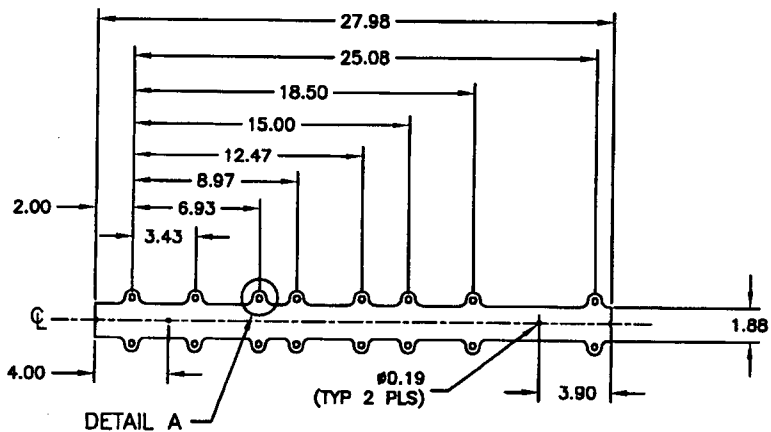
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

07.02.12 *PH*

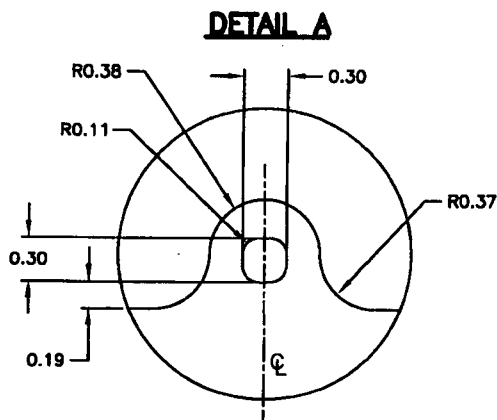
w/o 58819



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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